Work Order ID 50690

August 20, 2009 7:44:49 AM

Item ID: D3660-1
Revision ID: B
Item Name: CUFF

Start Date: 07/22/2009 **Start Qty:** 7.00
Required Date: 08/07/2009 **Req'd Qty:** 7.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** MF **Date:** 09-08-20 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Draw Nbr	Revision Nbr
D3660	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	BAND SAW	0.00							
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blank 7.300 " long								

09.08.20 (7)

110	DOOSAN LATHE	0.00							
Doosan	**Memo**	0.00							
Doosan Lathe	1-Turn as per folio FA 708 & DWG D3660, FOLIO REV: ~~AA~~ B DWG REV: B 2-Deburr as required								

09.08.20

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									

09.08.20 (7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00	OFS 09/08/20 (7)						
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00	MRS 09/08/20			(7x)	(0)		
HandFinish	**Memo**	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00	9-8-20 (7)						
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: 46	0.00							
	Memo	0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

9-8-20 (7)

09/08/25

W 9.08.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 20, 2009 7:44:49 AM

Work Order ID: 50690

Parent Item: D3660-1RevB

Parent Item Name: CUFF

Comments:

Start Date: 07/22/2009 **Required Date:** 08/07/2009

Start Qty: 7.00 **Required Qty:** 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6008-180RevA		Manufactured	No			100	Each	24.0000	4.0000			
Crosstube Extrusion												

cut-offs parts only

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	24	
39735	12	
46779	12	

40271 09.08.20 (x7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50690
Description: Cuff	Part Number:	D3660-1
Inspection Dwg: D3660 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	+/-0.010	3.950	✓			
3.075	+/-0.010	3.075	✓			
2.500	+/-0.010	2.500	✓			
1.700	+/-0.010	1.700	✓			
0.800	+/-0.010	.800	✓			
0.438	+/-0.010	.438	✓			
Ø0.128	+0.005/-0.001	.129	✓			
Ø0.230 x 100°	+/-0.010 x 0.5°	.222	✓			
Ø0.386	+0.005/-0.000	.390				
Ø2.990	+0.005/-0.000	2.992	✓			
Ø2.695	+0.005/-0.000	2.697	✓			
2.050	+/-0.005	2.050	✓			

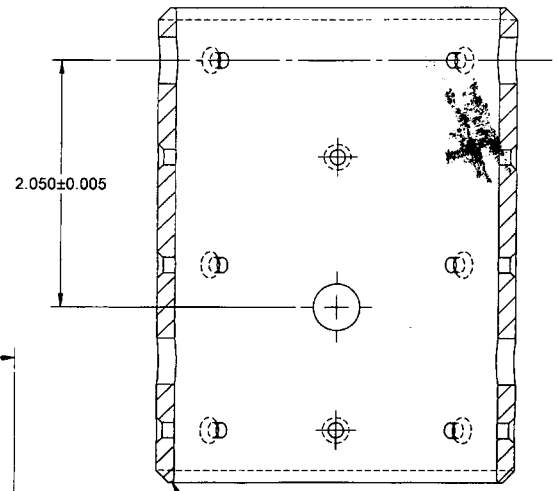
Measured by:	
Date:	09-08-20

Audited by:	J.F.S.
Date:	09/08/20

Prototype Approval:	N/A
Date:	N/A

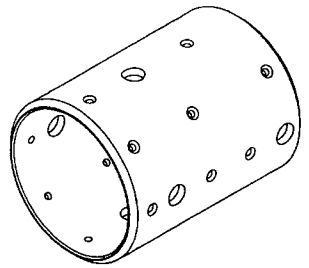
Rev	Date	Change	Revised by	Approved
A	08.05.12	New Issue	KJ/DD	

.193 .404

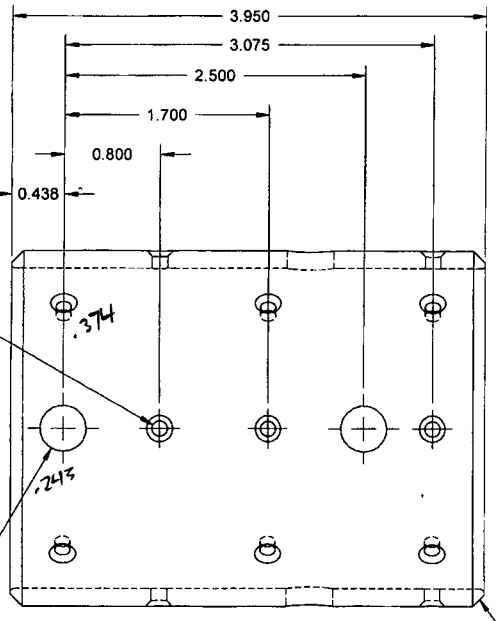


SECTION A-A

R0.032 TYP
INSIDE EDGES



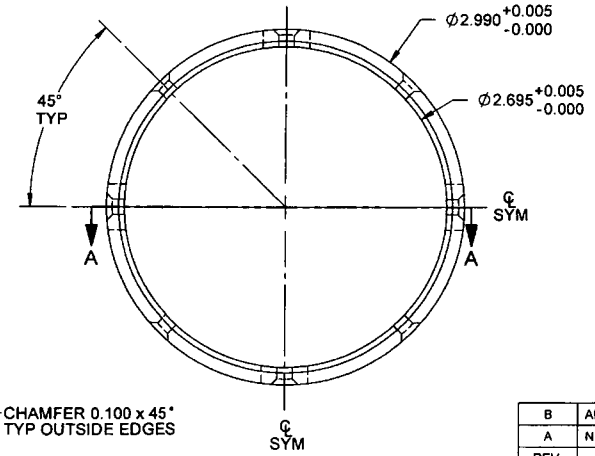
50690



DRILL #30 (Ø0.128 REF)
C'SINK Ø0.230X100°
TYP 22 PLACES
B

Ø0.386 +0.005 -0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES
B

CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES



D3660-1 CUFF

05-04-04 MP

NOTES:
1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.50 lbs

REV.	DESCRIPTION	BY	DATE
B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3660	REV. B
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE CUFF	SCALE NTS
DE APPR.			
DATE 08.03.03			

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